



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D206-642-314
Job Sheet 202828



Part No: D206-642-314

Job Qty: 1 pcs

Part Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/19

Job Tracking No:

Due Date: 12/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV Q SHEETS 29-30 IPP REV:A 11.11.18 NEW ISSUE DD VERF:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	12/2/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3	DAS	
							Packaging 1 - 4	74	
							Packaging 1 - 5	9-89	NOV 28 2019
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: S235787



Part: D206-642-314

Job No: 202828

Serial No/Batch: S235787

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/11/17, TC STC SH98-

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				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120 QC 4	1 pcs	12/2/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	DAS
				QC 4 - 75	78
				QC 4 - 78	9-89
130 Packaging 3-1 - Stock - B4B	1 pcs	12/2/19	0.00 0.00	Packaging 3 - 1 - B4B	DEC 0 6 2019
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
135 DC - 1 - B4B	1 pcs	12/2/19	0.00 0.00	DC - 1 - B4B	DEC 0 6 2019
				DC - 2 - B4B	
140 QC 21 - FG	1 pcs	12/2/19	0.00 0.00	QC 21 - FG - 21	DEC 0 6 2019
				QC 21 - FG - 70	DAS
					21
					9-89
Part Op 110 - Pick Kit Descriptions: 120 - QC4- 100% Inspect kits for completeness 130 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-314 Location: _____ PPP Rev: _____					

135 - Document Control Photocopy bluefile and create labels per PPP D206-642-314 CHG001
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5228782
AN4-6A	Bolt	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5228778
AN4C5A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5167345
AN5-10A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5122800
AN5-11A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5234196
AN5-12A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5663926
QC.4 D206-642-351	Replacement Skidtube, Low & High Gear, Run-on Landing Wearplates Fits LH or RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5231611
D206-648-013	Ground Handling Wheel Modification FG02	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5225612
D2652	Bushing	16 pcs (16 ea)	110-Packaging 1 - Pick Kit	5230376
D2712	Set Screw	10 pcs (10 ea)	110-Packaging 1 - Pick Kit	5169705
D2932-2	Saddle RH Out, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5220711
D2933-2	Saddle RH In, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218114
D2934	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5214496
D2935	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5219250
D2938-2	Saddle RH Out, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5232793
D2939-2	Saddle RH In, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5232295
D3407-043	Tow Ring	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5229819
D3413-1	O-Ring	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5226755
D3456-1	Washer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5198355
D3457-1	Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5216481
MS21042L3	Nut	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5218152
MS21042L4	Nut	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5228617
MS21043-4	Nut	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5225048
NAS1149C0463R Washer (AN960C416)		1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5104373-1
NAS1149D0363J Washer		8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5228336
NAS1149D0463J Washer		24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5225595
NAS1149D0563J Washer		8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5174288

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-41A	8	191	0
	AN4-6A	12	698	0
	AN4C5A	1	86	0
	AN5-10A	4	226	0
	AN5-11A	8	141	0
	AN5-12A	4	218	0
	D206-642-351	1	2	0
	D206-648-013	1	8	0
	D2652	16	523	0
	D2712	10	199	0
	D2932-2	1	6	0
	D2933-2	1	6	0
	D2934	2	32	0
	D2935	2	42	0
	D2938-2	1	6	0
	D2939-2	1	6	0
	D3407-043	1	10	0
	D3413-1	1	29	0
	D3456-1	1	130	0
	D3457-1	2	60	0
	MS21042L3	8	2,614	0
	MS21042L4	12	5,769	0
	MS21043-4	1	1,848	0
	NAS1149C0463R	1	157	0
	NAS1149D0363J	8	1,338	0
	NAS1149D0463J	24	7,700	0
	NAS1149D0563J	8	1,319	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4958-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4958-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4958-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q

Date: 13.08.12

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN980C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: Q
Date: 13.08.12



RELEASED
15.10.19

PPP

Part Number	D206-642-314	Box Part Number	BX104	Dimension	123" x 7" x 6.5"
Description	Skidtube, RH	Other Packaging	MF166		MF668
		Logo Decals	D2728-1		

Packaging Instructions and Decal Placement

D206-642-314

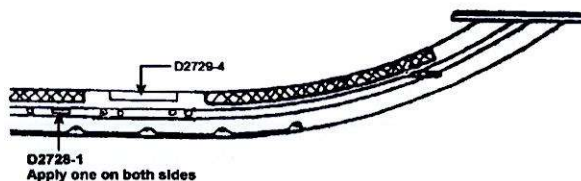
Apply labels D2729-4 and D2728-1 as per drawing.

Wrap skidtube in plastic. Place (2) pieces of MF166 at each ends of the box and glue to interior. Place (3) pieces of MF668 in bottom of box. Place skidtube in box. Wrap the (2) lugs in double foam and place in the front where the curve is. Put in a piece of foam with a cardboard cut to 38" long and 5 3/4" high in the middle of the (2) pieces of MF668 and place the saddle and hardware so they don't touch the skidtube and there is no movement.

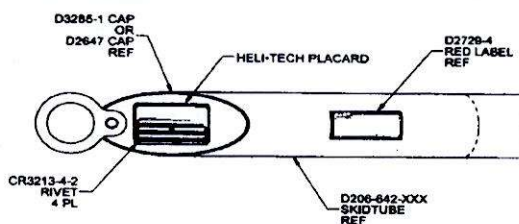
Put (3) pieces of MF668 on top to correspond with bottom foam already in place. Close box.

Apply Dart tape. Apply strapping after first Dart logo, thereafter applying strapping after every second Dart logo.

Apply clear tape over strapping. Apply label D2729-3 as per instructions in QSI 014.



For skidtubes that are manufactured as a PMA replacement part, a Heli-Tech placard and the D2729-4 label must be installed on the skidtube as per drawing below.



D2729-4

D2729-3

DART			
US #5735484 / CA #2222184 / EURO #0828655			
PART NO	D206-642-314	QTY	CHG001
DESC	Skidtube, RH	QTY	SH98-4
QTY	BXXXXXX	QTY	SA00475SE
REMARKS	Bell 206L/L1/L3/L4/407		

DART AEROSPACE		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200
SKIDTUBE, RH		
P/N: D206-642-314	CHG001	
B/N: BXXXXXX		

Revision: B
Date: 15.10.19

15/10/19